

Work Order ID 150621

Monday, August 29, 2016 2:49:08 PM

150621

Page 1

Item ID: 647.7703

Revision ID:

Item Name: Strut Assembly

Start Date: 7/29/2016 Start Qty: 4.00

Required Date: 8/29/2016 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: AUG 30 2016 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

647.7700

A2

110

Pick Kit

0.00

110

Packaging

Memo

0.01

Packaging

4 EL 16-10-6

120

Weld per dwg A/R 4130 rod Batch: M127925 0.00

120

Large Fab

Memo

0.07

Large Fab

1- ASSEMBLE AND WELD AS PER DWG

***IMPORTANT DIMENSION IS 8.35" ***

4 EL 16-10-6

130

QC9- Inspect visual per QSI004- Fusion Welds 0.00

130

QC

Memo

0.01

Quality Control

4 OCT 06 2016 DAS 24 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 2

Item ID: 647.7703 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Assembly
Start Date: 7/29/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/29/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				(4)			 OCT 06 2016
150 *150* Outsource3 Outsource process - Cad plate	Outsource process-Cadplate per QSI017 4.1.9.1 Memo Issue P/O : _____ C of C is required PLEASE NOTE ON PO: CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD	0.00 80.00				4x			 NOV 15 2016
160 *160* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.01				4			 NOV 18 2016

DQA: _____ Date: _____



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170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.01				4			
Quality Control	INSPECT USING GO/NO GO GAUGE								DAS 38 9-88 NOV 16 2016
180		0.00							
180									
SprayPaint	Memo	0.17				4			
Spray Painting	PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG								
	PRIMER BATCH: <u>134100</u>								16-11-21
190	QC14- Inspect Spray Paint	0.00							
190									
QC	Memo	0.01				4			
Quality Control									DAS 38 9-88 NOV 22 2016

DQA: _____ Date: _____



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Item Name: Strut Assembly
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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200	Identify as per dwg & Stock Location: <u>CCT/14</u>	0.00							
200									
Packaging	Memo	0.01							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.07							
Quality Control									

DAS
21
9-89
NOV 2 3 2016

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		OTHER : ☐																																																																						

Picklist Print

Monday, August 29, 2016 2:49:07 PM

Page 1

Work Order ID: 150621

150621

Parent Item: 647.7703

647 7703

Parent Item Name: Strut Assembly

Start Date: 7/29/2016

Required Date: 8/29/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7712 *647 7712* Strut Tube		Manufactured	No				Each	43.0000	**	4		EL 16-10-5	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA002			43						
				140985			1						
				145176			42						
647.7713 *647 7713* Strut Thread		Manufactured	No				Each	25.0000	**	4		EL 16-10-5	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA002			25						
				145177			2						
				148267			23						
647.7714 *647 7714* Strut Tube		Manufactured	No				Each	13.0000	**	4		EL 16-10-5	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA001			13						
				141911			1						
				145178			12						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coor. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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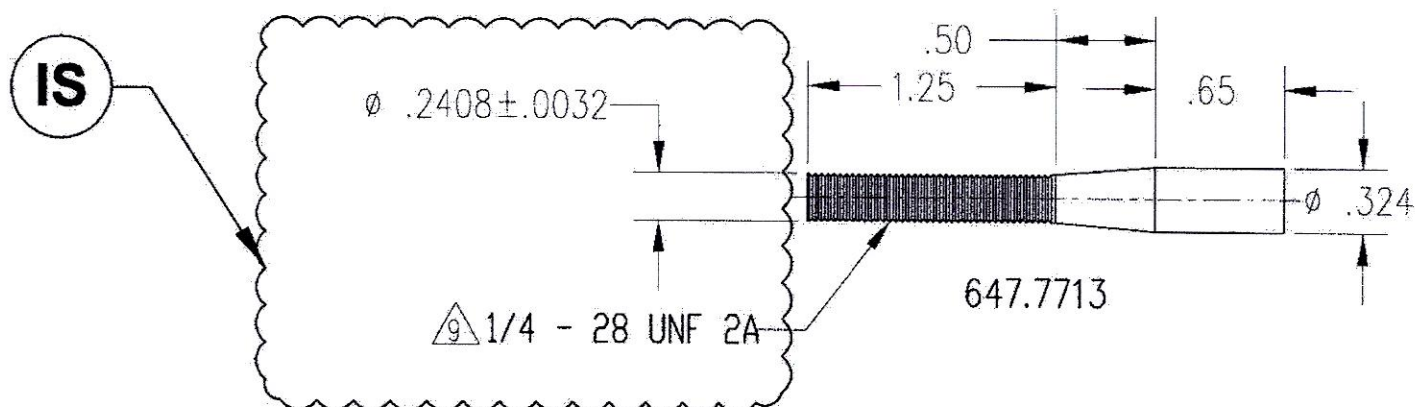


APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO. 05397		SHEET 1 OF 1	
DWG NO. 647.7700	REV: A	PREPARED BY T. CROSS	DATE: 05/02/16
DWG TITLE: STRUT ASSY			EFFECT ON DWG ☐ INC. ☒ UNINC.
APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: <i>[Signature]</i>
REASON: REVISED DIMENSION			CURRENT ORDER
			ECR: 16-028
			ACTION LIST: 1.

SHEET 2, ZONE D4 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 150621 MWS
16-08-30

DOCUMENTS EFFECTED:	☐ PATTERN	☐ MDL	☐ INSTALL INSTRU	☐ ICA	☐ BOM	CHANGE CATEGORY	☐ MAJOR	☒ MINOR	DER REVIEW REQUIRED	☐ YES	☒ NO
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APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05110

SHEET 1 OF 1

DWG NO. 647.7700

REV: A

PREPARED
BY

A. QUAN

DATE: 08/21/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: REVISED FINISH CALLOUT AS PER ECR 15-209

SHEET 1, NOTES IS:

ACTION: UPDATE MO & WO

NOTES:

- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW QQ-P-416F CLASS I TYPE II
- 9 MASK THREAD PRIOR TO FINISH

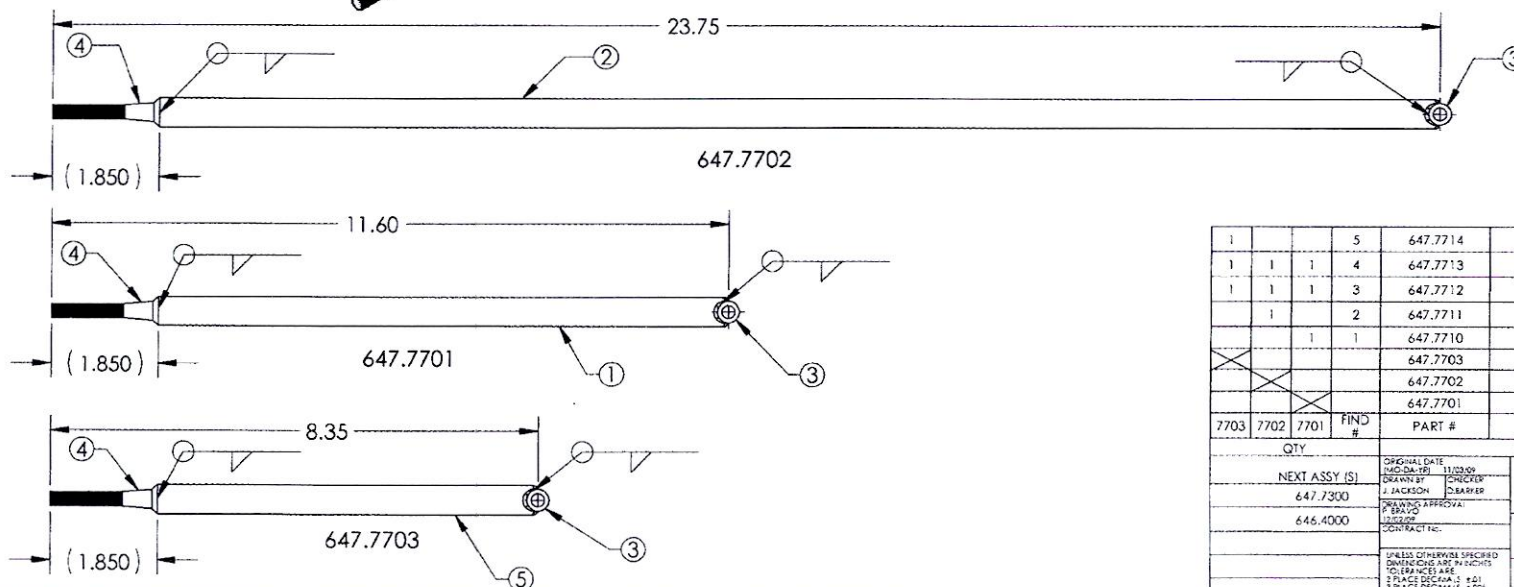
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM					
CHANGE CATEGORY				DER REVIEW REQUIRED	
☐ MAJOR ☐ MINOR				☐ YES ☐ NO	

1. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
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5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH

REV. SIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION PR2		N/C
N/C	INITIAL RELEASE	12/02/09	P. BRAVO
A	INCORPORATED ECU (0474)	11/13/14	P. BRAVO

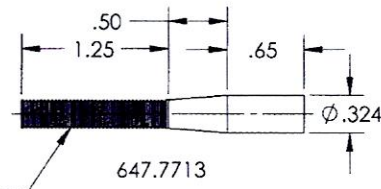
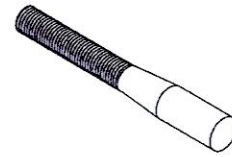
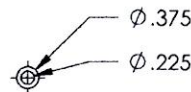
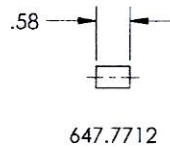
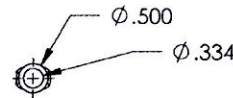
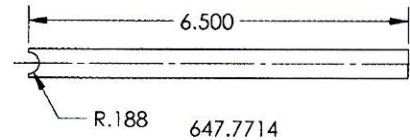
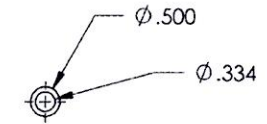
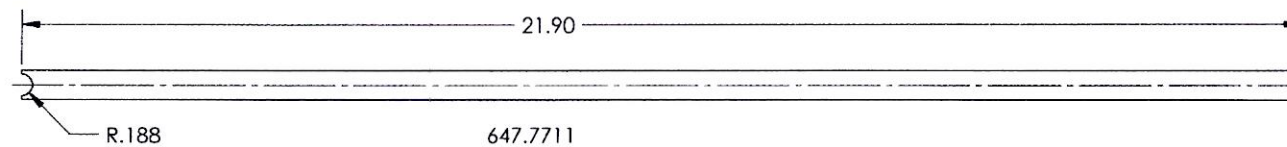
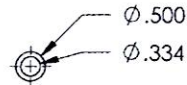
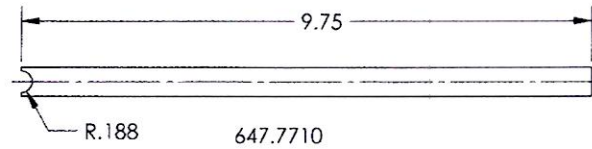
UNINCORPORATED ECN(S)

05/10, 05397



				5	647.7714	STRUT TUBE	△	
1	1	1		4	647.7713	STRUT THREAD	△	△
1	1	1		3	647.7712	STRUT TUBE	△	
		1		2	647.7711	STRUT TUBE	△	
		1	1		647.7710	STRUT TUBE	△	
X					647.7703	STRUT ASSY		△ △
	X				647.7702	STRUT ASSY		△ △
		X			647.7701	STRUT ASSY		△ △
7703	7702	7701	FIND #		PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST				
NEXT ASSY(S)				APICAL INDUSTRIES				
647.7300				2608 TEMPLE HEIGHTS DR.				
				OCEANSIDE CA. 92056-3512 (760)724-5300				
646.4000				STRUT ASSY				
				REV: A 11/23/09 DRAWN BY J. JACKSON CHECKED BY DEARBER PROJECT APPROVAL: P. BRAD CONTRACT NO.: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TO DECIMALS ARE: 1 PLACES DECIMAL = .251 3 PLACES DECIMAL = .005 ANGLES = °				
				REV: A REV B - PAGE CODE 3 / 27/16 SCALE NONE DWG. NO. 647.7700 SHEET 1 OF 6				

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



ORIGINAL DATE: 11/03/09 (A00-DA-10) DRAWN BY: J. JACKSON CHECKED BY: P. BEATO DRAWING APPROVAL:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		STRUT ASSY	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLAC. DECIMALS ±.01 3 PLAC. DECIMALS ±.005 ANGLES ±.5°		SET: B PAGE CODE: 07/M26 DWG. NO.: 647.7700	REV.: A
SCALE: NONE		SHEET 2 OF 2	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33948**

Purchase Order Date 10/14/2016

PO Print Date 10/14/2016

Page Number 2 of 2

Order From :
GROUP ALTECH
2455 HALPERN

ST LAURENT, MONTREAL H4S 1N9

VC-ALT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 514-335-3666

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FOB Origin

Line Total: \$24.58

4 150621 647.7703 STRUT 10/26/2016
Yes
10/26/2016

4.00 \$6.15 \$24.58

CAD PLATE PER QQ-P-416F, TYPE II, CLASS I

DAS
26
9-00

NOV 15 2016

Line Total: \$24.58

5 71401-45 PROCUREMENT 10/26/2016 1.00 \$0.00 \$0.00
QUALITY CLAUSES
No
10/26/2016

Procurement Quality Clauses
A004 FAA-PMA /TSO
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A024 PROCESS CERTIFICATIONS
A025 CERTIFICATE OF CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.00

PO Total: \$295.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 10/14/2016



2455, Halpern, Saint-Laurent, QUÉBEC, H4S 1N9
Tel.: (514) 335-3666 Fax.: (514) 335-3868
Internet : www.groupaltech.com

**Bon de livraison / Packing Slip
et / and
Certificat de conformité / Certificate of Compliance**

Bon-Livraison / Pk.Slip # : 122284-1 11/11/2016
Bon-Commande. / W.Order # : 122284
Client P.O. # : 33948
Transport :

Envoyé à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

Commandé par / Order by

DART AEROSPACE LTD (1427)
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

#	No. Job No. Réf	NoSerie / Part Number Nom Produit / Product	Traitement Process	Poids Weight	Qté Qty	Envoyé Sent	A venir BO
1	UNIT	646.3910 Rev.	CADMIUM QQ-P-416F TY:2 CL:2 + HYDRO ENBRITAL RELIEF	0.00	20	20	0
2	UNIT	646.3912 Rev.	CADMIUM QQ-P-416F TY:2 CL:2 + HYDRO ENBRITAL RELIEF	0.00	20	20	0
3	UNIT	647.7703 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1 + HYDROGEN ENBRITALMENT RELIEF (BAKE)	0.00	4	4	0
4	UNIT	647.7703 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1 + HYDROGEN ENBRITALMENT RELIEF (BAKE)	0.00	4	4	0

NOV 15 2016

DAS
26
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

AK

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.